

AMENDMENTS TO CLAIMS

This listing of claims will replace all prior versions, and listings, of claims in the application:

Listing of Claims:

1. (Currently Amended) A multiple discharge-servo curve control method for an electrical discharge machine, which comprises the steps of:

- (1) constructing discharge-servo curves ~~based~~ by inputting gap-voltage deviation and cutting speed records obtained under different cutting conditions, and pre-storing the discharge-servo curves in a discharge-servo curve database;
- (2) retrieving an initial one of said discharge-servo curves and performing a cutting procedure under control of a processing control program by referring to said initial one of said discharge-servo curves;
- (3) adding a discharge-servo curve instruction to said processing control program, said discharge-servo control instruction specifying an nth discharge-servo curve;
- (4) when the processing control program detects said discharge-servo curve instruction, retrieving said nth discharge-servo curve from said database;
- (5) swapping said nth discharge-servo curve for said initial one of said discharge-servo curves and continuing said cutting procedure under control of the processing control program by referring to said nth discharge-servo curve.

2. (Previously Presented) A multiple discharge-servo curve control method of electrical discharge machine as claimed in claim 1, wherein said different conditions involve different electrode-materials.

3. (Previously Presented) A multiple discharge-servo curve control method of electrical discharge machine as claimed in claim 1, wherein said different conditions involve different work-piece materials.

4. (Previously Presented) A multiple discharge-servo curve control method of electrical discharge machine as claimed in claim 1, wherein said different conditions involve different cutting solution-materials.

5. (Canceled)

6. (Canceled)

7. (Previously Presented) A multiple discharge-servo curve control device of electrical discharge machine, comprising: a storage unit arranged to pre-store discharge-servo curve data; a setting unit, which sets the numerical value of discharge-servo curve parameter; a reading unit connected to the storage unit, which retrieves the pre-stored discharge-servo curve data from the storage unit in according with the numerical value of discharge-servo curve parameter defined in the setting unit;

a program unit, which executes a machining program to control work-piece machining based on a first set of discharge-servo curve data; and

an instruction-judging unit connected to the program unit and the reading unit, the instruction-judging unit being arranged to detect a discharge-servo curve instruction in the machining program, retrieve designated discharge-servo curve data, and swap the retrieved discharge-servo curve data for the first set of discharge-servo curve data to match real machining needs.